

Date: Thursday, 19/03/2009 11:04:18 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID
Job Number : 46577	
Estimate Number : 10552	
P.O. Number :	Part Number : D206642312
This Issue : 19/03/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : L
Previous Run : 39151	Material :
Written By :	Due Date : 15/04/2009 Qty: 1 Um: Each
Checked & Approved By : JLD 09.03.19	
Comment : Est Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC	

Est Rev:K 07-12-04 ECN 1080p DD verified by:ec
 Est Rev:L 08-09-29 as per DSI9421 DD verified by:ec
 Est Rev:M 09-03-02 as per DSI9440 rev.a verified by:
 Est Rev:N 09-03-03 as per DSI9421 rev.b verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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H for JLD 09/04/08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

5 09/04/08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	46577A	206 L HIGH GEAR SKIDTUBE
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S



Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

1 x D206-642-341 Batch 46577A SD

4.0	D206648013	GHW Modification
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CHG001



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification

batch: B43186

SS 09/04/07 (X)

5.0	AN4C5A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

batch: M 104936

SS 09/04/07 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46577

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch:

M100993

7.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ring

batch:

33949

8.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

BUSHING

Pick:

Qty	Part Number	Description	Batch
16	D2652	Bushing	44278
1	D206-642-341(REF)		

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty	Part Number	Description	Batch
10	D2712	Set Screw	43818

10.0

D29322

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2932-2	Saddle	40280

11.0

D29332

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
			41129

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 46577

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2933-2 Saddle

12.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description Batch
2 D2934 Saddle Spacer

Batch

44296

88 09/04/07 (X)

13.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description Batch
2 D2935 Saddle Spacer

Batch

44553

88 09/04/07 (X)

14.0

D29382

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch
1 D2938-2 Saddle

Batch

41131

88 09/04/07 (X)

15.0

D29392

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch
1 D2939-2 Saddle

Batch

41131 41441

88 09/04/07 (X)

16.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch:

43308

88 09/04/07 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: 43002

18.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 44603

19.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: M111177

20.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

8

AN3-41A

Bolt

M111163.

21.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

12

AN4-6A

Bolt

M116399

22.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4

AN5-10A

Bolt

M116363

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46577

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

(or AN5-11A)

Choice of bolt will depend on crosstube

23.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number Description Batch

4 AN5-11A Bolt

(or AN5-12A)

Choice of bolt will depend on crosstube

M116363

SS 09/04/07 (X)

24.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD10 Washer

M116523

SS 09/04/07 (X)

25.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

24 AN960JD416 Washer

M116363

SS 09/04/07 (X)

26.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD516 Washer

M116523

SS 09/04/07 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46577

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Pick:

Qty Part Number Description Batch
8 MS21042L3 Nut

M116399

28.0

MS21042L4

Nut



Comment: Qty.: ~~12.0000~~ Each(s)/Unit Total : ~~12.0000~~ Each(s)

NUT 13.000

13.000

Pick:

Qty Part Number Description Batch
13 MS21042L4 Nut

M1169262

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-312

Location:

PPP Rev: F

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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